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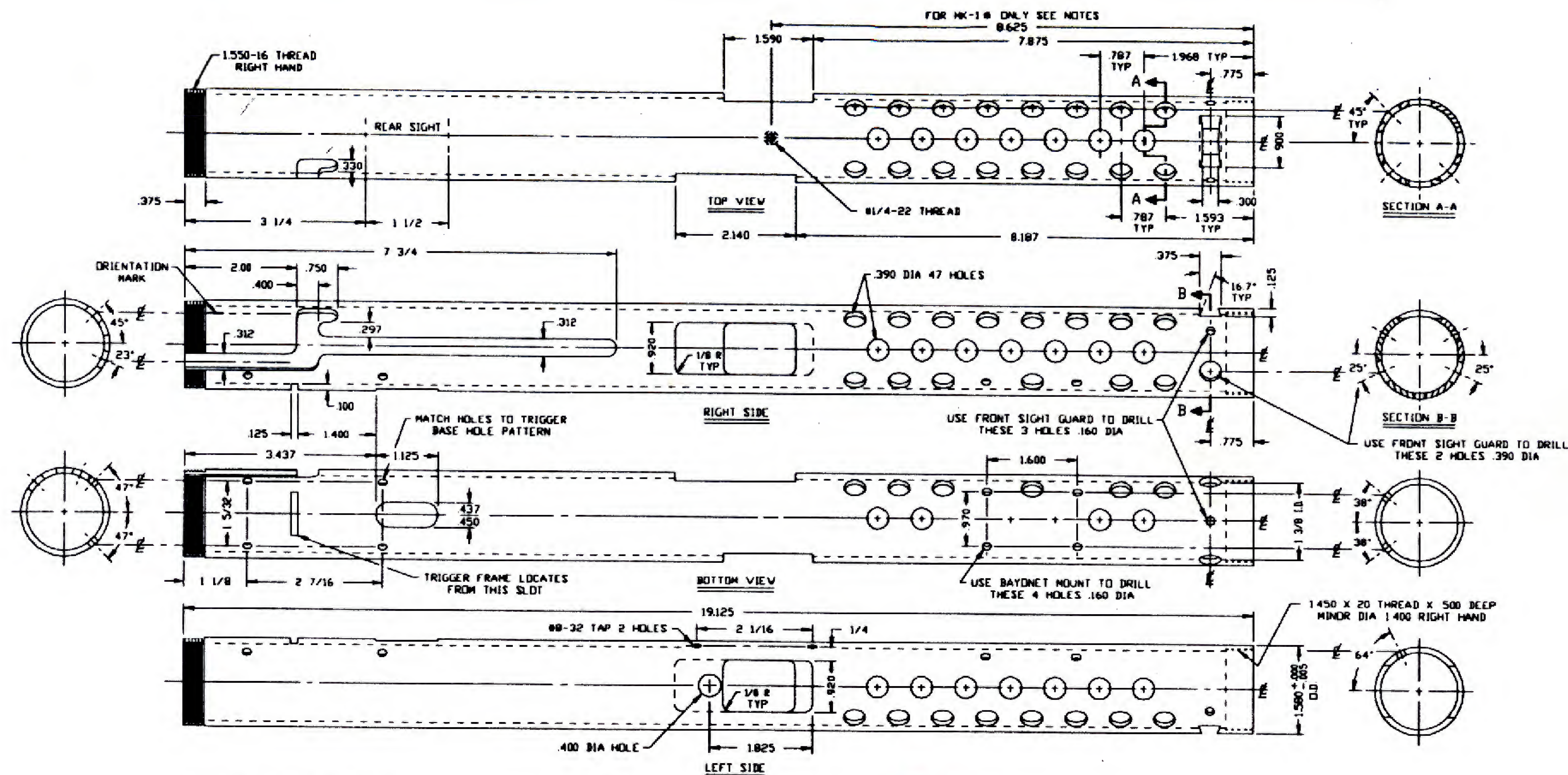
1- scale print of THOMPSON SUB MACHINE GUN M1A1

1- scale print of MK 1 and MK 1* LANCHESTER

1- scale print of MODEL 37 right and left side plates

1- scale print of UD-M42

PARTS SUPPLIERS ON LAST PAGE



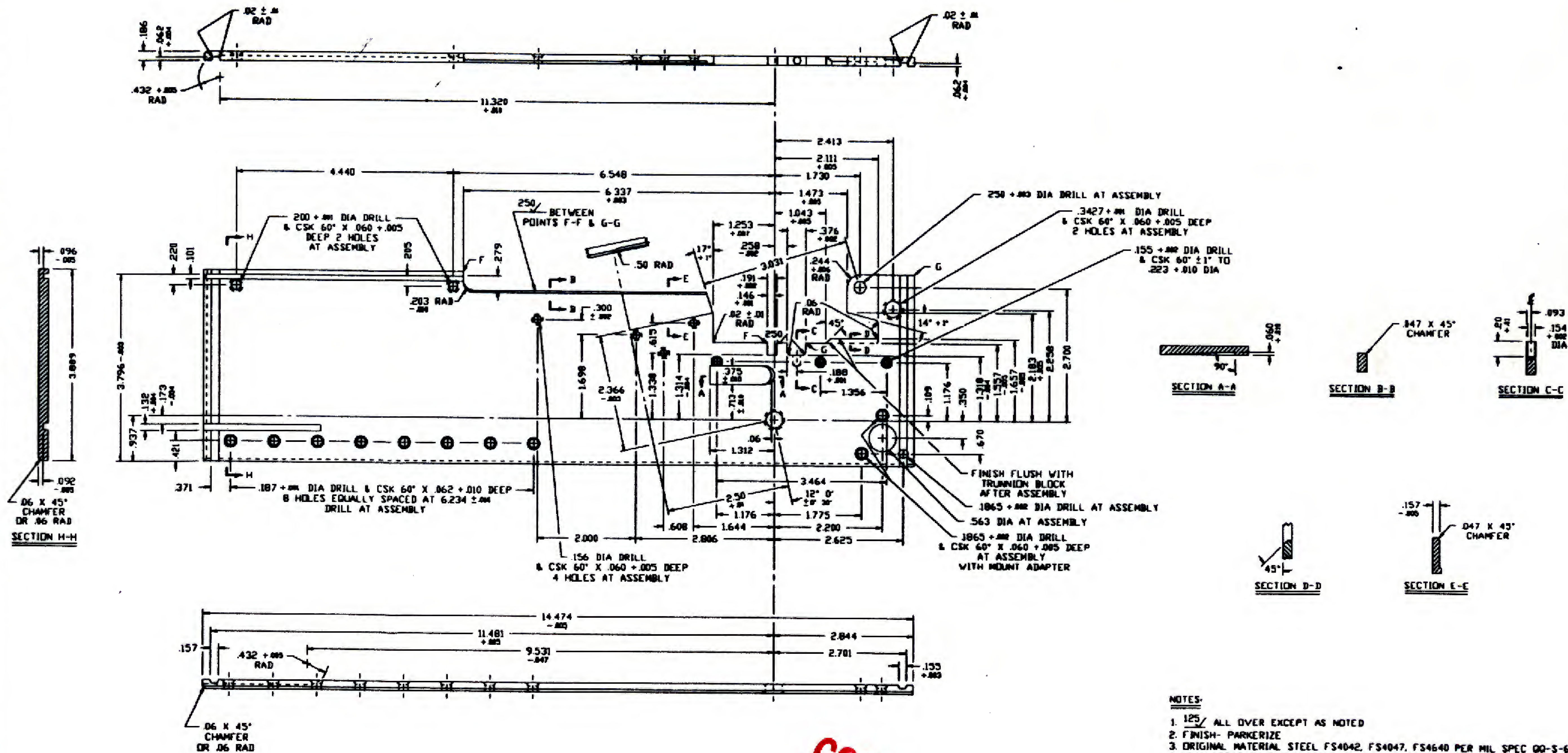
GENERAL NOTES AND SUGGESTIONS

1. TURN O.D. AND THREAD BOTH ENDS FIRST.
2. MARK 1* IS THE LATER MODEL, FULL AUTO, AND HAS 1/4-22 SCREW IN TOP OF MAGAZINE HOUSING THAT LOCKS BARREL IN PLACE. TAP THIS HOLE & MAGAZINE HOUSING 1/4-20 AND USE ORIGINAL SCREW OR MAKE ONE.
3. ALL 160 HOLES WERE ORIGINALLY RIVET HOLES. I DRILL THESE HOLES #29 (.136) AND TAP 88-32 USE 88-32 X 1/4 ROUND HEAD MACHINE SCREWS.
4. WITH END CAP IN PLACE TIGHT, BACKOFF 1/8 TURN AND MAKE A LINE-UP MARK ON BOTH PARTS. PLACE TUBE IN STOCK AND LOCK END CAP IN PLACE. SLIDE MAGAZINE HOUSING ON TUBE AND LOCATE IN STOCK AND INSTALL HINGE SCREW. SPOT DRILL THRU MAGAZINE HOUSING FOR 2 88-32 SCREWS. DRILL #29 AND TAP 88-32 AND INSTALL 2 88-32 SCREWS. THE ORIGINAL ONES FIT. THIS ESTABLISHES THE HOUSING TO THE END CAP. ALL OTHER HOLES ARE RELATIVE TO THE 2 PARTS.
5. LOCATE ALL OTHER HARDWARE BY SPOT DRILLING IN PLACE.
6. MAIN PORTS CAN BE SCRIBED WHILE HOUSING IS IN PLACE. EXTRACTION PORT SIZE IS CORRECT, BUT MAGAZINE HOUSING HOLE IS LARGER.
7. THESE DIMENSIONS WERE COMPILED FROM 3 LANCASTER RECEIVERS.
8. FRONT SIGHT DOVETAIL IS NOT A STANDARD TAPER MACHINE A STRAIGHT SLOT AND TRIM FRONT SIGHT TO FIT AND SOLDER IN PLACE.
9. FINISH BLUE ALL STEEL PARTS. BRASS SHOULD BE NATURAL, NOT PAINTED.
10. BAYONET: ENFIELD P1907 LONG OR P1907/42.
11. MATERIAL: 1 5/8 O.D. X 1 3/8 I.D. DOM 1020 STEEL TUBE.

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SCALE	FULL	DRAWING	SEE NOTE 11	CRS		TOLERANCES
FINISH		FINISH	SEE NOTE 9	DATE		REC 2 PL ± .005
TITLE	MK-1 & MK-1B LANCASTER RECEIVER			REV.		REC 3 PL ± .005
						ANGLES ± .5°
						NO.

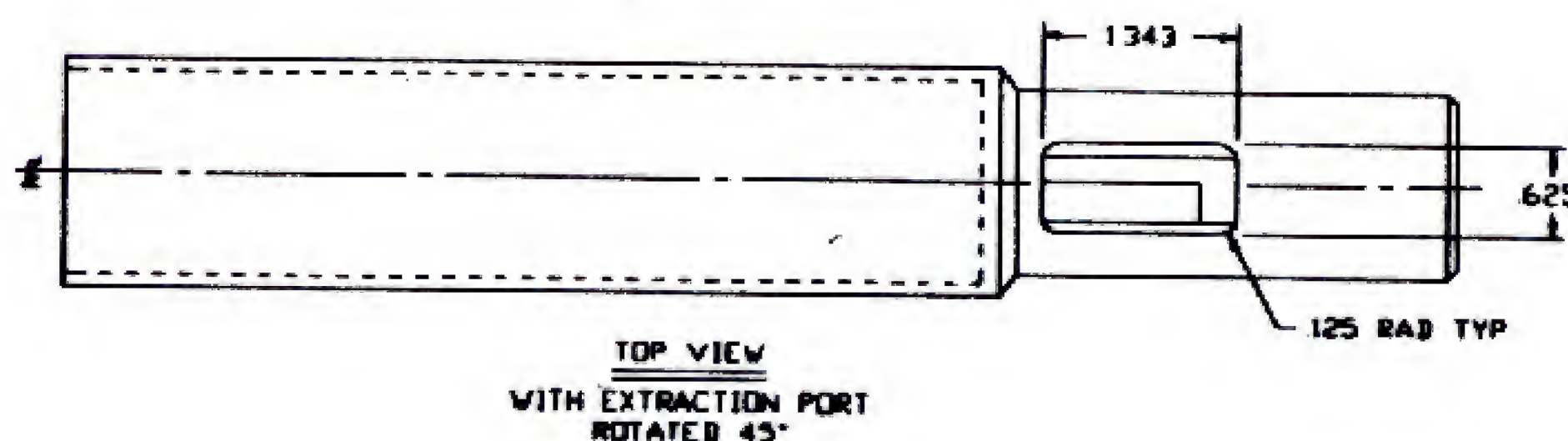
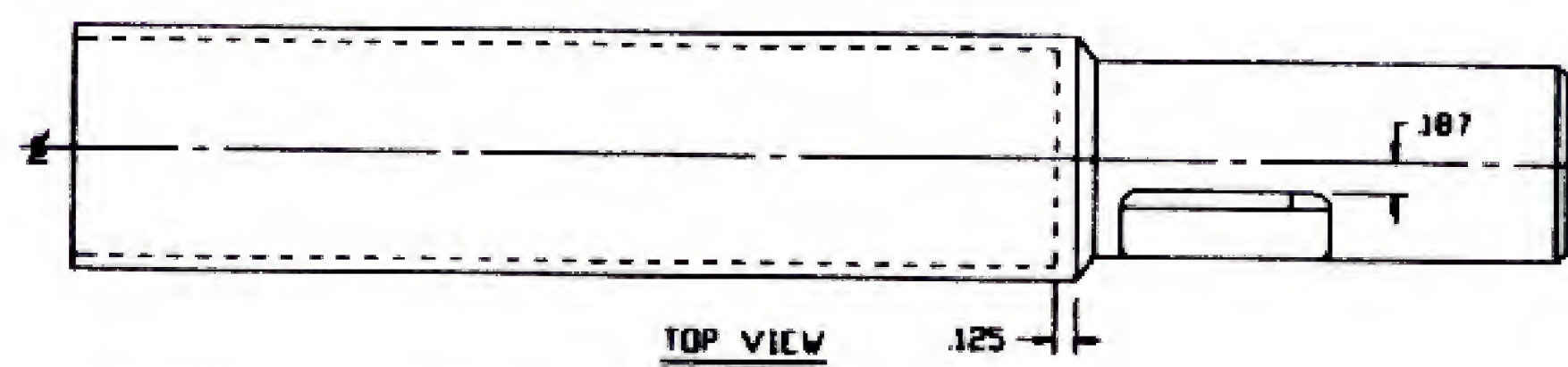
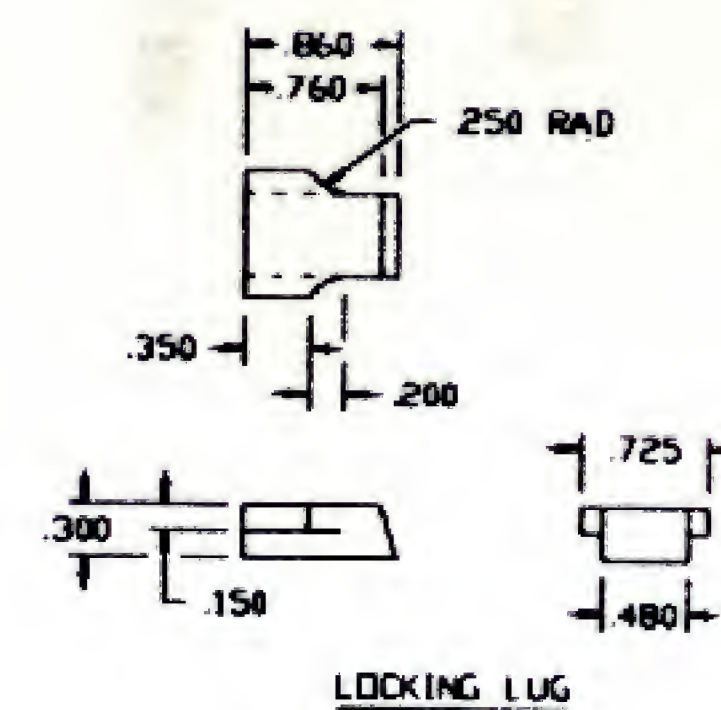
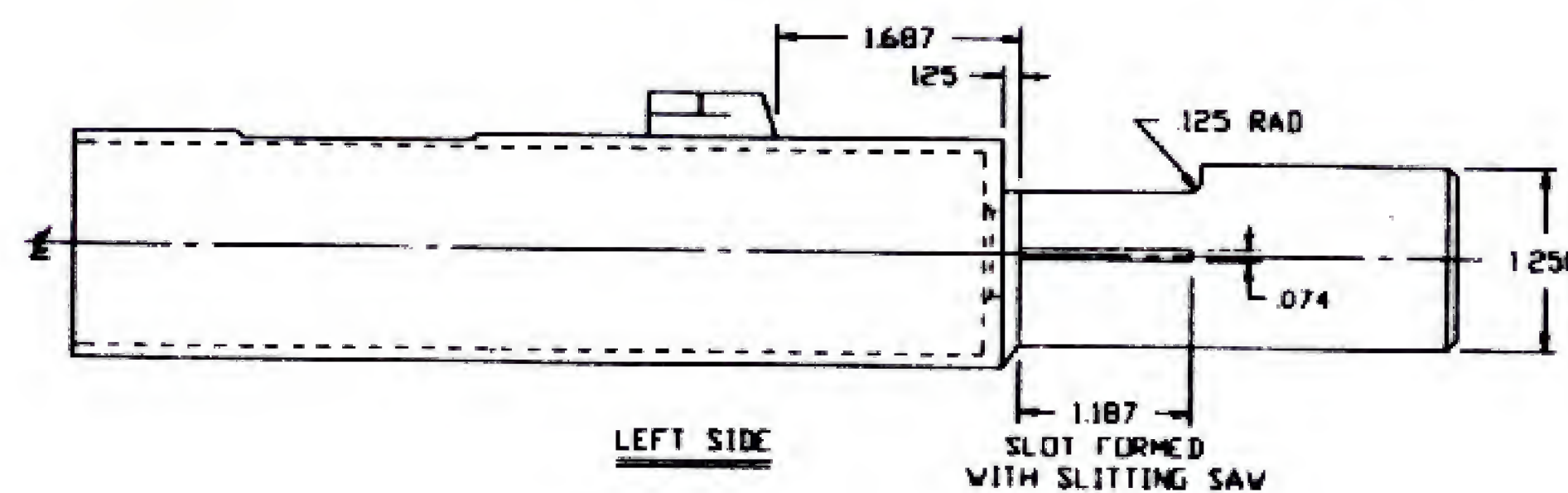
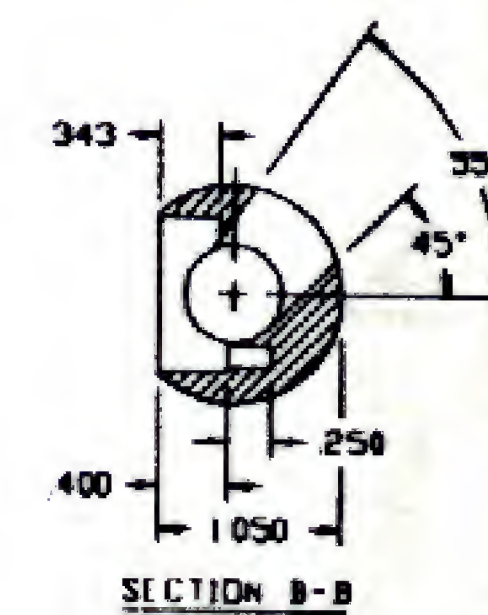
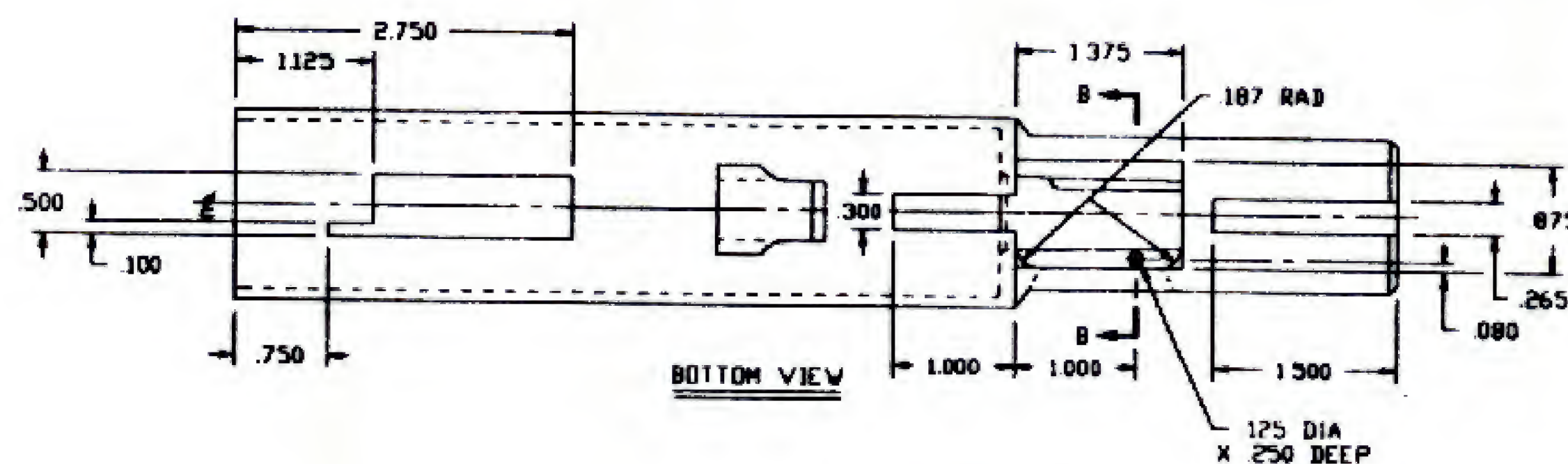
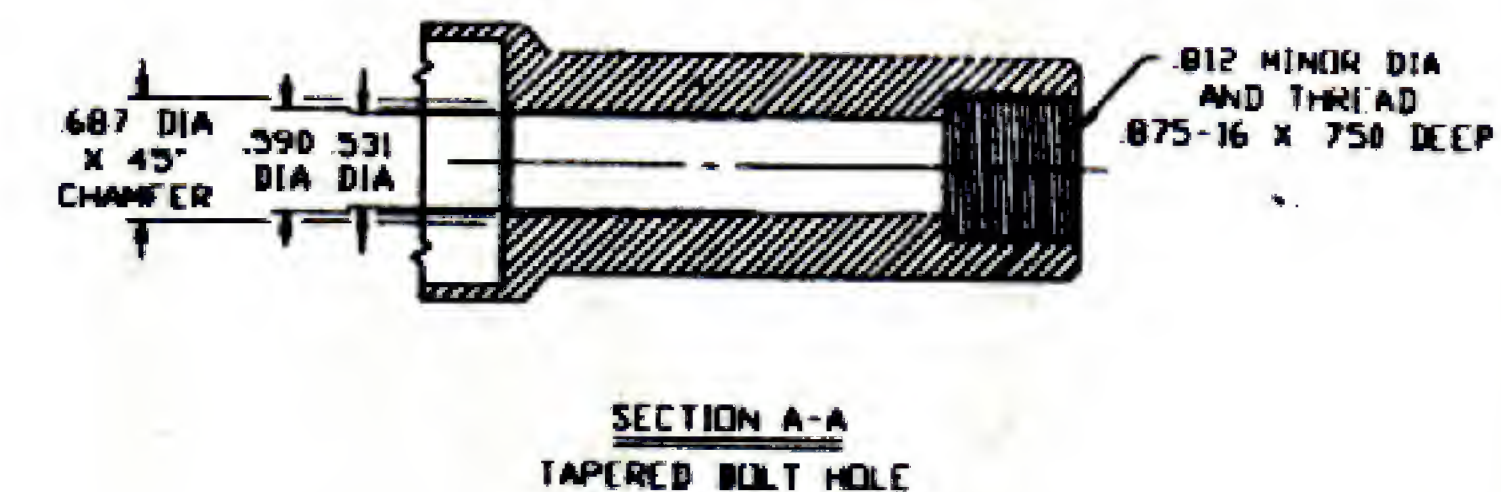
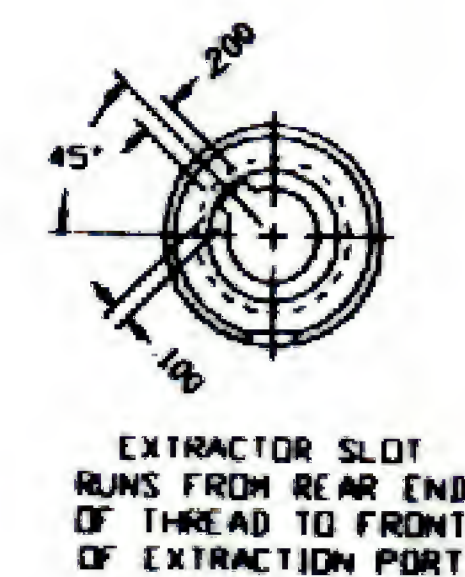
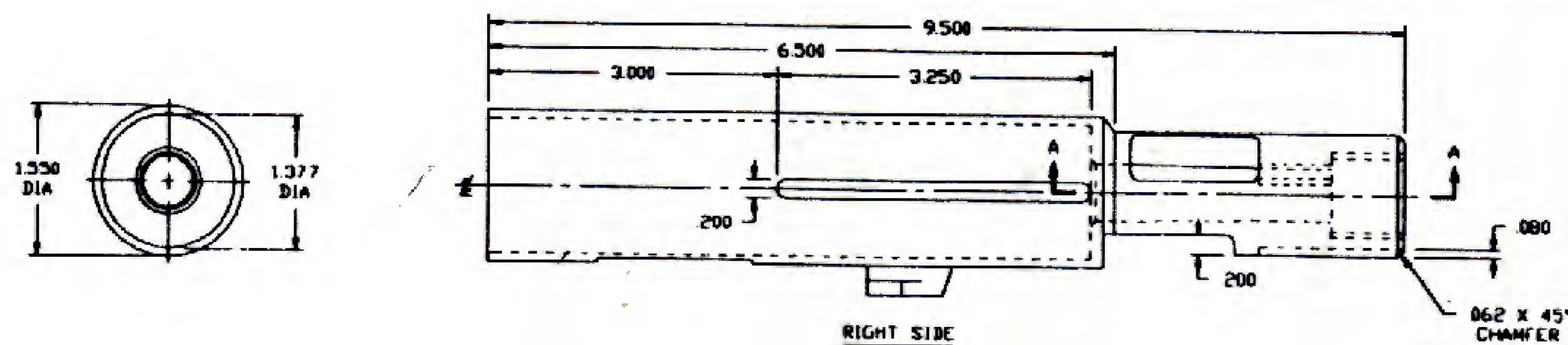


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 MATERIAL

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DRAWN FROM ORD. PART NO. 7100702
 ROCK ISLAND ARSENAL
 DEPT OF THE ARMY
 ROCK ISLAND, ILL.

SCALE	FULL	MATERIAL	DATE	REV.	TOLERANCES
		SEE NOTE 3			DECIMALS
		SEE NOTE 2			ANGLES
		MODEL 37			
		LEFT HAND SIDE PLATE			



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MATERIAL**

NOTES:

1. MATERIAL - COLD ROLL, HOT ROLL, 4130, 4140 OR 4340 STEEL
2. FINISH - BLUE
3. HEAT TREATMENT - 4130, 4140, 4340 28-32 R/C

SCALE	FULL	MATERIAL	SEE NOTE 1	DATE	TOLERANCES
FIN		FINISH	SEE NOTE 2		DEC. 2 PL. 2
TITLE	UD-M42 RECEIVER			REV.	DEC. 2 PL. 2
					ANGLES : 8°

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**